



DEPARTMENT OF THE NAVY
HEADQUARTERS, UNITED STATES MARINE CORPS
WASHINGTON, DC 20380-1775

NORMAL

TI 4733-15/11G
31 July 2000

U.S. MARINE CORPS TECHNICAL INSTRUCTION

INFANTRY WEAPONS GAGE CALIBRATION PROGRAM

Encl: (1) Sample Calibration Request
(2) Sample IWGCP Packing List
(3) Sample Return Receipt Form

1. Purpose. To provide procedures and instructions for the operation of the Marine Corps Infantry Weapons Gage Calibration Program (IWGCP).

2. Cancellation. TI 4733-15/11F.

3. Information

a. Calibration of Infantry Weapons Gages (IWGs) requires high accuracy precision measurements and special instrumentation. Marine Corps field calibration facilities have limited capabilities to perform calibration of these gages.

b. The IWGCP has been developed at Marine Corps Logistics Base (MCLB), Albany, Georgia to provide Marine Corps units within the Marine Forces (MARFOR), bases, posts, stations, Marine Barracks, detachments afloat, Marine Corps Reserves, Maritime Preposition Ships (MPS), and the Norway Air Landed Marine Expeditionary Brigade (NALMEB) a way to obtain calibrated IWGs. The following provides information on the program.

(1) For gages listed in this Technical Instruction (TI), calibration service is at no cost to the user with the exception of MPS and NALMEB.

(2) Gages maintained in the IWGCP pool are listed in paragraph 5.

(3) Calibrated pool gages will be shipped to the user. Once received, users will ship uncalibrated gages back to MCLB Albany. If pool assets are not available, user's gages will be calibrated and returned.

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(4) Calibration of non-pool gages will normally be accomplished by the nearest MCLB at user's expense. Calibrated gages are obtained by sending a Naval Message (NAVMSG), FAX, or e-mail request (internet e-mail address: mbmatcomiwgcp@matcom.usmc.mil) to the Maintenance Center, Attn: Electronic Business Center [IWGCP], 814 Radford Boulevard STE 20325, Albany, Georgia 31704-0325, DSN 567-6390/5395, FAX Commercial (912) 439-6152, DSN 567-6152.

(5) Requests should be made at least 60 days prior to date calibrated gages are required to ensure exchange gages arrive by the required date.

(6) Service requests must identify the Ordnance Part Number (OPN), nomenclature, and quantity of gages required as well as a complete shipping address, including Activity Address Code (AAC), point of contact, and telephone number.

(7) Users must return identical gages requiring calibration to the IWGCP within 5 working days from receipt of the calibrated gages.

(8) MPS and NALMEB gages will be furnished to IWGCP prior to receiving calibrated gages or as agreed upon in Memorandum Of Understanding's/Memorandum Of Agreement's between MCLB Albany and MPS/NALMEB.

NOTE

The IWGCP provides calibrated gages to participating units in exchange for gages they have in their possession. The IWGCP is not a supply point for initial issue of gages to field units.

4. Major Items Affected

<u>Description</u>	<u>NSN</u>	<u>TAM No.</u>	<u>I.D. No.</u>
KIT, Boresight (7.62MM)	4933-00-930-1957	E0143	08945A
LAUNCHER, Grenade 40MM (M203)	1010-00-179-6447	E0892	07700A
MACHINE GUN, .50 Caliber (M2)	1005-00-726-5636	E0980	02498B
TOOL AND GAGE SET, Intermediate Maintenance for Squad Automatic Weapon (SAW) M249	5180-01-150-0357	E1983	08748A
KIT, Tool Small Arms units, Field Maintenance, for Machine Gun 7.62MM and Mounts	4933-00-999-4810	E2095	03023B
KIT, Tool Field Maintenance for Machine Gun, .50 Caliber	4933-00-726-5830	E2270	04033A
TOOL AND GAGE SET, Direct and General Support Maintenance, for Rifle, 5.56MM, M16	4933-00-056-7106	E2525	06229A
KIT, Tool Intermediate Maintenance for Machine Gun M240	5180-01-147-2468	E2656	08722A
KIT, Tool Organizational Maintenance for Machine Gun M240	5180-01-147-2467	E2829	08724A
KIT, Tool Small Arms Repairman	5180-00-357-7770	E2900	00607A

<u>Description</u>	<u>NSN</u>	<u>TAM No.</u>	<u>I.D. No.</u>
KIT, Tool Boresight Fixture Rocket Launcher Mark 145 MOD O	4933-01-200-1575	E2070	08969A
TOOL SET, Intermediate Maintenance for Machine Gun, MK 19, MOD 3, 40MM	5180-01-143-9604	E3093	08669A
*FIXTURE, Measuring, Trigger Pull	4933-00-647-3696	N6020	07849A
TOOL AND GAGE SET, Field Maintenance, Third and Fourth Echelon for Rifle 7.62MM, M14	4933-00-647-3703	N6170	03024A
MACHINE GUN, .50 Cal XM-293/M3P (AVENGER)	1005-01-303-5250	E0990	10152A
CALIBER .50 TANK INBORE TRAINING DEVICE (AIMTEST)	1005-01-464-2468	N6018	10612A

5. Components Affected

<u>Description</u>	<u>Weapon</u>	<u>NSN</u>	<u>OPN</u>
GAGE, Profile (Striker, 81MM)	M252	5220-01-441-4158	11580237
GAGE, Bore Straight	M252	5220-01-343-2225	11580040
GAGE, Headspace	M40A1		61046-0
GAGE, Headspace	M40A1		61046-1
GAGE, Headspace	M40A1		61046-2
GAGE, Headspace	M40A1		61046-3
GAGE, Headspace	M40A1		61046-4
GAGE, Headspace	M40A1		61046-5
GAGE, Headspace	M40A1		61046-6
GAGE, Headspace	M40A1		61046-7
GAGE, Headspace	M40A1		61046-8
GAGE, Go Magazine Well	MP5		303030
GAGE, Plug No-Go	MP5		305265
GAGE, Go & Symmetry Receiver	MP5		314035
GAGE, Profile (Firing Pin)	MP5	5220-01-383-2301	322165
GAGE, Profile (Extractor)	MP5	5220-01-379-0243	322161
GAGE, Assembly Bore Constriction, (40MM)	MK19	1010-01-138-4862	3269536

<u>Description</u>	<u>Weapon</u>	<u>NSN</u>	<u>OPN</u>
GAGE, Headspace and Timing, (.50 Caliber)	M2	5220-00-535-1217	5351217
GAGE, Breechbore, Machine Gun (Barrel Erosion)	M2, M3P	5210-00-317-2502	7274725
GAGE, Ring Plain (Wear Check)	M2, M3P	5220-00-317-2503	7274730
GAGE, Block (Firing Pin Protrusion)	M14, M40A1, DMR	5210-00-345-6122	7274736
GAGE, Firing Pin Protrusion	DMR	5220-00-653-3373	7274754
GAGE, Plug, Plain Cylindrical	M14	5220-00-647-3693	7274755
GAGE, Snap, Fixed	M14, DMR	5220-00-647-3695	7274757
* FIXTURE, Measuring, Trigger Pull	ALL	4933-00-647-3696	7274758
GAGE, Breech, Bore	M14, DMR	5220-00-647-3697	7274761
GAGE, Headspace	DMR	5220-00-921-6054	7274746
GAGE, Headspace	M14	5220-00-647-3698	7274790
BOLT, Field Test	M14	5220-00-647-3699	7274799
GAGE, Breech, Bore Machine Gun	M2, .50 Cal	5210-00-731-9900	7319900
GAGE, Plug, Plain Cylindrical	M14, DMR	5220-00-745-8398	7458398
GAGE, Plug Plain Cylindrical	M2	5220-00-507-7200	5077200
GAGE, Plug, Plain Cylindrical	M14	5220-00-745-8598	7458598
TOOL, Alignment	M14		7799708
GAGE, Gap Setting	M14	5210-00-986-3159	7799705
GAGE, Headspace	M16 Series, M4A1 CQBW	5220-00-070-7814	7799734
GAGE, Firing Pin Protrusion	M16 Series, M4A1 CQBW	5220-00-070-7815	7799735
GAGE, Firing Pin Protrusion	M2, .50 Cal	6695-00-197-4421	7799739
SIGHT, Bore, Optical (Telescope, Elbow 5X)	UGWS, SMAW, M242, M240 Series	4933-00-867-6607	7799773
GAGE, Straightness (Bore)	M16 Series, M4A1 CQBW	5220-00-221-9391	8448202
GAGE, Barrel Erosion	M16 Series, M4A1 CQBW	5220-01-014-8183	8448496
GAGE, Headspace	M82A1A		8594106

<u>Description</u>	<u>Weapon</u>	<u>NSN</u>	<u>OPN</u>
GAGE, Headspace	M82A1A		8594108
GAGE, Headspace	M82A1A		8594100
GAGE, Headspace	M82A1A		8594111
GAGE, Headspace	M82A1A		8594112
GAGE, Headspace	M82A1A		8594116
GAGE, Breechbore Machine Gun (Barrel Erosion)	M249	5210-01-259-3454	9350096
GAGE, Headspace	M249	1005-01-141-3830	9350102
GAGE, Firing Pin Protrusion	M249	5220-01-141-4732	9350104
GAGE, Headspace	M240 Series	4933-01-043-8212	11826274
GAGE, Muzzle & Breech Wear	M240 Series	5220-01-082-5564	11826276
GAGE, Breechbore Machine Gun (Erosion)	M240 Series	5210-01-082-1714	11826298
GAGE, Headspace	M240 Series	4933-01-043-8211	11826299
GAGE, Firing Pin Protrusion	M240 Series	4933-01-043-9450	11826304
GAGE, Firing Pin Protrusion	M203	5220-00-348-8434	12002976
GAGE, Plug Plain Cylindrical	M16A1	5220-00-310-0573	12003832
GAGE, Plug Taper Cylindrical	M16 Series	5220-01-043-9473	12006472
GAGE, Cannon Bore Erosion (120MM)	M1	5210-01-280-5223	12520840
ADAPTER, Gun Mounting Aircraft (Boresight Adapter)	25MM	1005-01-253-0778	12524144
GAGE, Cannon Barrel Erosion	M242	5210-01-329-4860	12535035
GAGE, Plug Plain Cylindrical	M16 Series	5220-01-075-5004	12620101
GAGE, Headspace and Timing	M3P		352997001
BORESIGHT, Adapter (.50 Caliber)	UGWS	4933-01-343-2223	50C1253G1
ADAPTER, Optical Boresight, 83MM	SMAW	4933-01-269-4937	50C1265G1
BORESIGHT, Adapter (40MM)	UGWS	4933-01-343-2224	50D1240G1
BORESIGHT, Adapter (7.62MM)	M240 Series	4933-01-343-2222	50C1254G1
ADAPTER, Optical Boresight, 9MM	SMAW	4933-01-273-3071	50C1261G1
GAGE, Profile (Bore)	SMAW	5220-01-269-7609	82A5027A8052
GAGE, Profile (Headspace, No-Go)	SMAW	5220-01-272-8868	82A5027A8053-1

<u>Description</u>	<u>Weapon</u>	<u>NSN</u>	<u>OPN</u>
GAGE, Profile (Headspace, Go)	SMAW	5220-01-270-1112	82A5027A8053-2
TEST, Electrical Circuit, Rock (Energy Output, Millijoule)	SMAW	4933-01-273-9861	82A5027A8080
GAGE, Firing Pin Protrusion, Go/No-Go	AIMTEST		A50203
GAGE, Firing Pin Whole Diameter, Go/No Go	AIMTEST		A50204
GAGE, Headspace, Go	AIMTEST		50207
GAGE, Headspace, No-Go	AIMTEST		50208

*Calibrate prior to initial issue only and affix a Calibration Not Required (CNR) label if no periodic intermediate maintenance is required; using unit(s) may request calibration if no CNR label or serial number is assigned by IWGCP. See current edition of TI 8005-24/20 for further information.

6. Action

a. Commander, Marine Corps Systems Command (PM TMDE/CTMS)

- (1) Provide policy, guidance, and technical direction for IWGCP.
- (2) Provide funds for operation of IWGCP.
- (3) Approve all additions/deletions for IWGCP, and, based on recommendations from Commander, Marine Corps Systems Command (CBG), establish quantities for all gages to be held in pool.

b. Commander, Marine Corps Systems Command (Director CBG)

- (1) Introduce no new gages to IWGCP without prior approval from Commander, Marine Corps Systems Command (PM TMDE/CTMS).
- (2) Provide funding for new gages for newly fielded systems that are placed in the pool.

c. Commander, Marine Corps Logistics Bases, Albany, Georgia

- (1) Maintain a pool of calibrated IWGs of sufficient quantity to support the annual exchange of organizational and intermediate maintenance IWGs in use Marine Corps wide. Dispose of all unserviceable IWGs received from field and stock, in accordance with DoD Directive 4160.21-M-1 Defense Demilitarization Manual.
- (2) Calibrate IWGs in accordance with NWAS, MS-43 approved calibration procedures/guides.
- (3) Provide IWG calibration support, when requested by using units, in accordance with this TI.

(4) Ship IWGCP items under priority 06 based on a force activity designator of III and an urgency designator of B as directed by the current edition of MCO 4400.16. In all cases, the Required Delivery Date (RDD) will be 15 days. Ship IWGCP items to all MARFOR units Outside Continental United States (OCONUS) through Air Mobility Command (AMC), priority TP-02 with a designated RDD.

(5) Provide Commander, Marine Corps Systems Command (PM TMDE/CTMS) recommended changes to update this TI as required.

(6) Provide Commander, Marine Corps Systems Command (PM TMDE/CTMS) any recommendations for enhancing the technical or operational aspects of the IWGCP.

(7) Introduce no new gages to IWGCP without prior approval from Commander, Marine Corps Systems Command (PM TMDE/CTMS).

(8) Conduct a physical inventory of all pool assets and calibration standards annually prior to 1 February.

d. Using Units

(1) Ensure IWGs are calibrated at required intervals with the exception of (OPN 7274758) Trigger Pull Measuring Fixture, which is calibrated in accordance with the current edition of TI 8005-24/20.

(2) Submit Calibration Requests to IWGCP for those IWGs that will require calibration during any anticipated deployment time by Naval Message, FAX, letter, or e-mail.

(3) Request IWGCP calibration support using the format provided in enclosure (1).

(4) Inventory gages upon receipt and validate against packing list provided (see enclosure (2)).

(5) Retain packing list as certification of calibration of IWGs.

(6) Extract the calibration due date from packing list and make required entries of due date(s) on appropriate calibration control record(s) per the current edition of TM 4700 -15/1.

(7) Sign and return receipt of IWGs (see enclosure (3)) to IWGCP when gages are received. This action is required to ensure that IWGs have reached the proper destination and to ensure accuracy of record keeping process.

(8) Return gages requiring calibration to the IWGCP using traceable means no later than 5 working days after receiving calibrated gages using shipping container(s) in which calibrated gage(s) were received. MARFOR units and OCONUS units ship gages using AMC, priority TP-02 with a designated RDD or send gages United States Postal Service (USPS) mail.

(9) Ship all IWGs that are excess to unit's Table of Equipment (T/E), to Maintenance Center, Attn: Electronic Business Center [IWGCP], 814 Radford Boulevard STE 20325, Albany, Georgia 31704-0325 for calibration and redistribution. Do not turn IWGs over to the supply system, local calibration facility, or the Defense Reutilization Marketing Office (DRMO).

(10) Notify IWGCP immediately of any change to unit AAC/address.

(11) Replace all gages that are lost or damaged at unit's expense. Units must report serial numbers of lost gages to IWGCP and requisition replacement gages through supply system. All gages must be calibrated prior to use.

(12) Units will conduct annual physical inventory listing IWGCP serial numbers and furnish results to IWGCP Program Manager no later than 1 February. This will confirm correctness of unit's account. If requested by unit, IWGCP will furnish a current inventory of that unit's account.

BY DIRECTION OF THE COMMANDANT OF THE MARINE CORPS

OFFICIAL



J. G. KINES for,
Director, Technical Data Management Division
Marine Corps Logistics Bases
Albany, Georgia

DISTRIBUTION: PCN 167 383572 00

SAMPLE CALIBRATION REQUEST

FM: CG SECOND MARDIV CAMP LEJEUNE NC//CODE//

TO: CG MCLB ALBANY GA//886//

UNCLAS//N04700//

SUBJ: SHIPPING INSTRUCTIONS

REF/A/DOC/TI4733-15/11G

1. IAW THE REF, REQUEST FOLLOWING CALIBRATED GAGES BE SHIPPED TO AAC M53520:

NOMENCLATURE	OPN	QTY
GAGE, BARREL EROSION	7799792	001
GAGE, BORE STRAIGHTNESS	8448202	001

2. SHIPPING ADDRESS: CO MARINE BARRACKS, U.S. NAVAL SUBMARINE BASE, NEW LONDON, GROTON, CT 06340.

3. POC: MSGT U. S. MARINE, DSN: 883-2234, COMM (505) 412-2234.

NOTE

For FAX, letter or E-mail, submit all pertinent information in a like format.

ENCLOSURE (1)

1 / (2 blank)

SAMPLE IWGCP PACKING LIST

UNITED STATES MARINE CORPS
 INFANTRY WEAPONS GAGE CALIBRATION PROGRAM (IWGCP)
 814 RADFORD BOULEVARD
 MARINE CORPS LOGISTICS BASES
 ALBANY, GEORGIA

12/14/96

PACKING LIST

1. These gages were serialized by IWGCP. **DO NOT** change the assigned serial number.
2. Please sign and mail the return receipt form.
3. Update your calibration records with "CALIBRATED BY IWGCP"
4. Ship identical OPN and quantity of uncalibrated gages within 5 working days using this container(s) and the enclosed address label.
5. Any questions should be directed to IWGCP Program Manager, DSN 567-6390 / FAX DSN 567-6152, Commercial (912) 639-6390/5395, FAX (912) 639-6152, or leave message on the recorder DSN 567-6390, Comm (912) 639-6390.

<u>SERIAL</u>	<u>OPN</u>	<u>NOMENCLATURE</u>	<u>AAC</u>	<u>DUE DATE</u>
05760	12620101	GAGE, PLUG, PLAIN	00870	12/96

PACKED BY _____

DATE _____

ENCLOSURE (2)

1 / (2 blank)

SAMPLE RETURN RECEIPT FORM

UNITED STATES MARINE CORPS
INFANTRY WEAPONS GAGE CALIBRATION PROGRAM (IWGCP)
814 RADFORD BOULEVARD
MARINE CORPS LOGISTICS BASES
ALBANY, GEORGIA

12/14/96

RETURN RECEIPT

1. These gages have been received, inspected, and accepted.
2. The exchange shipment will be returned within five (5) working days.

<u>SERIAL</u>	<u>OPN</u>	<u>NOMENCLATURE</u>	<u>AAC</u>	<u>DUE DATE</u>
05760	12620101	GAGE, PLUG, PLAIN	00870	12/96

RECEIVED BY _____

DATE _____

ENCLOSURE (3)

1 / (2 blank)